



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400220
Job Sheet 181621



Part No: RBT400220

Job Qty: 2 ea

Part Name: Wrench Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/2/18

Job Tracking No:

Due Date: 10/2/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT400220 Rev.1B IPP Rev. A 18.08.02 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs		10/2/18	0.00	0.00	Purchasing		SEP 25 2018
110	Packaging	2 pcs		10/2/18	0.00	0.00	Packaging2		SEP 25 2018
120	QC	2 pcs		10/2/18	0.00	0.00	QC6		38
130	Packaging	2 pcs		10/2/18	0.00	0.00	Packaging3		9-89
140	QC21-FG	2 Ea		10/2/18	0.00	0.00	QC21		SEP 26 2018

Part Op 100 - Issue PO to P.J. MACHINAGE P/O: 040724 MANUFACTURE RBT400220 AS PER DWG -Certificate of Descriptions: conformity is required

aug 10, 2018 x 2 R h

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT400220P	Wrench Assembly	2 pcs (1 ea)	100-Purchasing	5113488

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBT400220P	2	0	0

Part Specifications

Specifications could not be found.

Plex 8/10/18 2:05 PM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S113489



Part: RBT400220

Job No: 181621

Serial No/Batch: S113489

Revision: 1B

Inspector:

Exp Date:

Instructions:

Date: 09/25/18

8124



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400220
Job Sheet 181621



10-17

Part No: RBT400220

Job Qty: 1 ea

Part Name: Wrench Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/2/18

Job Tracking No:

Due Date: 10/2/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBT400220 Rev.1B IPP Rev. A 18.08.02 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		10/2/18	0.00	0.00	Purchasing		
110	Packaging	1 pcs		10/2/18	0.00	0.00	Packaging2		
120	QC	1 pcs		10/2/18	0.00	0.00	QC6		
130	Packaging	1 pcs		10/2/18	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		10/2/18	0.00	0.00	QC21		

Part Op 100 - Issue PO to P.J. MACHINAGE P/O: _____ MANUFACTURE RBT400220 AS PER DWG -Certificate of Descriptions: conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT400220P	Wrench Assembly	1 pcs (1 ea)	100-Purchasing	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBT400220P	1	0	0

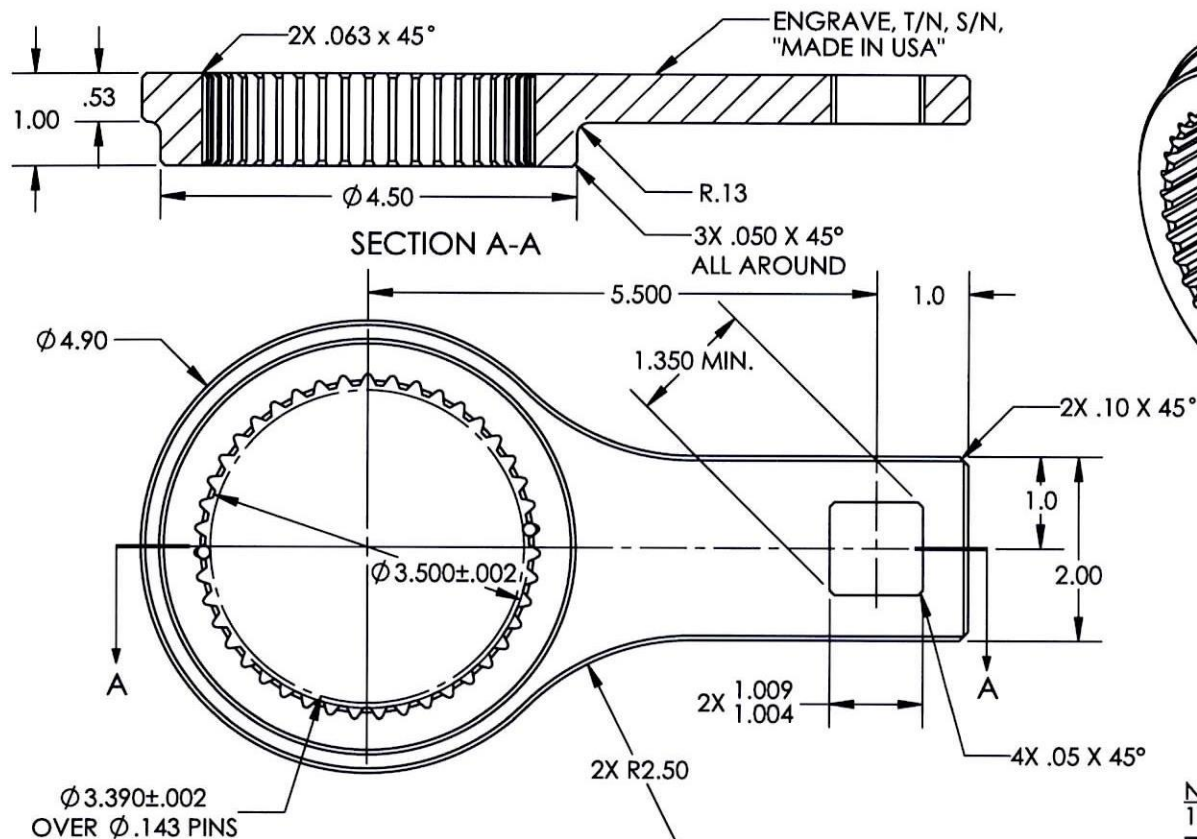
Part Specifications

Specifications could not be found.

Plex 8/2/18 8:38 AM dart.logan.david

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D RADIUS FROM R1.5 TO R2.5, CH'D LENGTH BETWEEN CENTER OF GEAR & CENTER OF SQUARE DRIVE FROM 5.000, CH'D SIZE OF SQUARE DRIVE TO STANDARD SIZE PER S.E.	3/13/2012	RJC	SE
1A	ADDED NOTE 1, REF. TOOL NUMBER: 407-240-008-101.	9/20/2012	RJC	SE
1B	ADDED ENGRAVING NOTE, ENGRAVE, T/N, S/N, "MADE IN USA". ADDED DIMENSION 1.350 MIN. CH'D B/O INFO WAS 1-1/8 X 9 X 5 IS 1 X 9 X 5.	7/16/2014	DJN	GE



NOTE:
1. REF. BELL TOOL NUMBER: 407-240-008-101.

		TITLE	
		WRENCH	
DWG NO.		REV	
RBT400220		1B	
MAT'L 4140		DRAWN BY: CLOUGH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D. Weil</i>	
.XXX ± .005 FRACTIONS ± 1/32		HEAT RC 32-37	
.XX ± .01 ANGLES ± 5°		FINISH CAD PLATE YELLOW	
.X ± .1		SPEC QQ-P-416F, TYPE II, CLASS II	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		BELL 407	
SCALE	1:2	DATE	3/12/2012
		SHEET 1 OF 1	

SPLINE DATA	
TYPE	INTERNAL
NO. OF TEETH	43
DIAMETRAL PITCH	12/24
PRESSURE ANGLE	30°
MINOR DIAMETER	3.500 ± .002
DIAMETER OVER Ø .143 PINS	3.390 ± .002

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	WRENCH	4140	1X 9 X 5	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040724

Supplier: PJM001-VC
P.J. Machinage
1381 Rte Cite-Des-Jeunes
St-Lazare
QC
J7T 2B8
Phone: 450-455-0705

PO No: PO040724
PO Date: 8/10/18
Due Date: 10/1/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

**E-MAILED
AUG 10 2018**

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181621	RBT400220P			Wrench Assembly	Firmed	-	10/1/18	2 pcs	0 pcs	2 pcs	\$1,168.00/pcs	\$2,336.00

Line Item Note W/O 181621

SEP 25 2018

Grand Total: \$2,336.00

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/10/18 2:15 PM dart.Lussier.Patrick

Shipping Order

10/08/2018

P.J. Machinage (9052 9470 Qc Inc).
1381, Rte Cité-Des-Jeunes,
St-Lazare, Qc
J7T 2B8
Tel : 450 455-0705

Order : 6907
Reference : PO : PO040724-S/O : 6907
Bid : 14922
Ship : Votre camion

Customer : 628

Ship To

Dart Aerospace Ltd. (C.O.D.)
Accounts payable
1270 Aberdeen St
Hawkesbury, Ontario
K6A 1K7

Same

Fax: 1 613 632-5246

Item No.	Description	Qty	Qty. Delivere	B/O Qty
001	Wrench Assembly Part # RBT400220 Rev. 1B ✓	2	2 ✓	0

P.J. Machinage retains ownership of all goods sold and other work-product delivered to or performed for its customer until full and complete payment of the underlying invoice, even in circumstances where the part to be machined or materials were provided by the customer. In cases where the part of materials belonged to the customer before it is remitted to P.J. Machinage for the purpose of performing work thereon, its delivery to P.J. Machinage shall entail a transfer of the underlying rights of ownership of the customer over said part or materials.

Shipping : Votre Camion
Package No : 24 109 12018
Merchandise Received: 24 109 12018

Ref. : Purelater, 1440 645 4059

PJ Machinage

Certificate of conformance

Sold to:

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON, K6A 1K7

Supplier address:

PJ Machinage
1381 Route Cité-Des-Jeunes
St-Lazare, Qc, J7T 2B8

Purchase Order: PO040724

This is to certify that the below names items were inspected and/or tested to your drawings, specifications and purchase order. Objective evidence are shipped with the products and are on file to support the verifications and/or tests and can be made available on request, unless otherwise noted.

DAS
38
9-88

<u>Part Number</u>	<u>Quantity</u>	<u>Description</u>
RBT400220 Rev. 1B	2	Wrench Assembly

 September 20, 2018



ACIER VANGUARD LTÉE

2205 de l'Aviation, DORVAL, QUÉBEC, Canada, H9P 2X6.

Tel: (514) 685-1515 fax: (514) 685-1516

CERTIFICATE OF COMPLIANCE / CERTIFICAT DE CONFORMITÉ

Order No. / No. Commande 135132	CUSTOMER / CLIENT P. J. MACHINING	Packing slip / No. d'expédition L48990-01	DATE 14-08-18
MATERIAL ID# / No. MATÉRIEL 2018-1245	GRADE / NUANCE AISI 4140	HEAT TREATMENT / TRAITEMENT THERMIQUE ANNEALED / RECUIT ADOUCI	HEAT / COULÉE J78-09692A
PAYS D'ORIGINE:	CHINA		
SHAPE / FORME Plate / Plaque	SIZE / DIMENSION 1.000" in.	SPECIFICATIONS ASTM A-829, A578 Class A	

CHEMICAL COMPOSITION / ANALYSE CHIMIQUE							
	Carbon (C)		Silicon (Si)		Manganese (Mn)		Phosphorus (P)
mini/maxi	0.380	0.430	0.150	0.350	0.750	1.000	0.035
actuel (%):	0.420		0.270		0.960		0.010
	Sulfur (S)		Chromium (Cr)		Nickel (Ni)		Molybdenum (Mo)
mini/maxi	0.040		0.800		0.000		0.150
actuel (%):	0.030		1.050		0.000		0.204
	Copper (Cu)		Vanadium (V)		Aluminium (Al)		Tungsten (T)
mini/maxi	0.350		---		---		---
actuel (%):	0.000		0.000		0.000		0.000

MECHANICAL PROPERTIES / PROPRIÉTÉS MÉCANIQUES				
Yield strength / Élasticité	Tensile / résistance à la traction	Elongation / allongement (%)	Reduction of area / surface (%)	surface hd / dureté
PSI	PSI			220 BHN

TESTS JOMINY / JOMINY RESULTS					
J	HRC	J	HRC	J	HRC
01	.	07	.	13	.
02	.	08	.	14	.
03	.	09	.	15	.
04	.	10	.	16	.
05	.	11	.	18	.
06	.	12	.	20	.
				22	.
				24	.
				26	.
				28	.
				30	.
				32	.

No weld repairs performed during the manufacturing of this product. We hereby certify that the above results have been verified and conform to the above mentioned specifications. Material is Mercury free, without radioactivity.

Aucune réparation exécutée par soudure durant la fabrication de ce produit. Par la présente nous attestons que les résultats ci-haut mentionnés ont été vérifiés et sont conformes aux spécifications. Pas de contact au Mercure, sans radioactivité.

Keith BALL - Branch Manager

QUANTITÉ:

7



NORONCA ASSEMBLY

PAGE No.:

001

MATÉRIEL:

414C

OBSERVATION: _____

SIGNATURE RESPONSABLE:

12.000

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329999	1

CLIENT / customer 238

P.J. MACHINAGE

1381 ROUTE LA CITÉ DES JEUNES

ST-LAZARRE

QC J7T 2B8

LIVRÉ À / shipped to:

P.J. MACHINAGE

1381 ROUTE LA CITÉ DES JEUNES

ST-LAZARRE

QC J7T 2B8

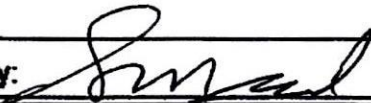
1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
135208	N/A	4140		
SPECIFICATIONS DU PROCÉDÉ processing specifications				
SEL HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	32 - 37 HRC	2	35 - 38 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
2	0	PIECES (2) PIECES 1 BOITE DE CARTON		

11/9/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

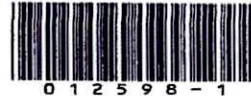


DATE: 2018-09-04

APPROUVÉ



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel.: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

012598- 1

Livré à / Ship to

PJ MACHINAGE

1381 Rte de la Cité-des-Jeunes
St-Lazare, QC, J7T2B8
CANADA
Tel.: 450-455-0705 Fax.: 450-455-1167

Client / Customer:

PJ MACHINAGE

1381 Rte de la Cité-des-Jeunes
St-Lazare, QC, J7T2B8
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courtier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
18-Sep-2018		AZIZ DHANANI				135277			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBT400220 Rev.	WRENCH 01 -CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-416, TYPE II, CLASS II: *** 02- BAKE	CADMIUM CH	2	2	0	0	0	
2	RBT400220 Rev.	WRENCH 01 -BAKING, HYDROGEN EMBRITTEMENT RELIEF	BAKE MIN-CHG	2	2	0	0	0	

DAS
38
9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.

*La responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.

*Legal responsibility will not be higher than the amount of invoice.

erDataSoft

User ID AZIZ